

Date: Thursday, 26/02/2009 11:41:02 AM
 User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : RIB ASSY (BASKET LID, RH) |
| Job Number | : 46089 | | |
| Estimate Number | : 13663 | | |
| P.O. Number | : | Part Number | : D3836042 |
| This Issue | : 26/02/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3836 REV A |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 44019 | Drawing Revision | : A |
| | Type | Material | : |
| | : LARGE FAB ASSY | Due Date | : 04/03/2009 |
| Written By | : | Qty: | 2 Um: Each |
| Checked & Approved By | : <u>JULIA DAWSON</u> | | |
| Comment | : Est Rev:A 08-12-01 new issue DD verified by:eC | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer Bushing B 39560

Batch: B40390 → 2x

SAD 09/03/23

2.0

304 SQ Tube .75x.75x.065W

304 SQ Tube .75x.75x.065W



Comment: Qty.: 1.8698 f(s)/Unit Total: 3.7397 f(s)

304 SQ Tube .75x.75x.065W

batch: M110561

SAD 09-03-19 (2)

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

SAD 09-03-19 (2)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-03-20 (2)

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg

D3836

1- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: M109775

SAD 09/03/23 (2x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 26/02/2009 11:41:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 46089

Part Number: D3836042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- grind weld flush where indicated on dwg D3836

4- deburr if necessary

Handwritten: 09/03/23 (2)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: PD 09-03-23 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: S 09/03/23 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Handwritten:* LWA

Handwritten: SAD 09-03-23 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/03/24

Job Completion



Handwritten: MF 09-03-24

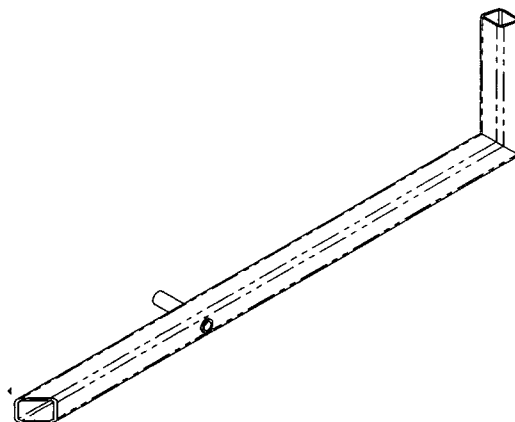
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

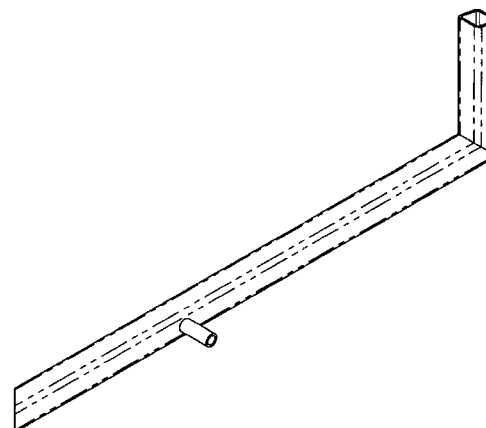
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

Handwritten: 46089

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 2 | | X | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 3 | 1 | 1 | D2327-3 | SPACER BUSHING |
| 4 | 1 | | D3836-1 | RIB |
| 5 | | 1 | D3836-2 | RIB |
| 6 | 1 | 1 | D3836-3 | RIB |

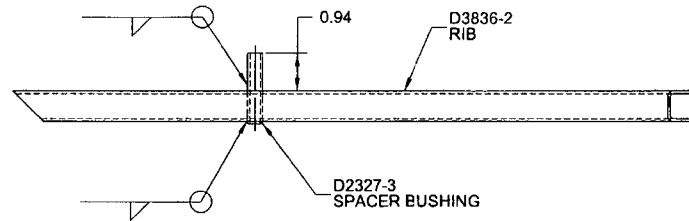
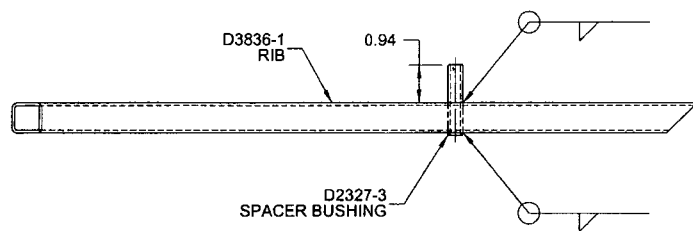
RELEASED
Handwritten signature/initials

| | | | | | |
|---|--|--|--|--------------|----------|
| A | | NEW ISSUE | | MB | 08.09.24 |
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3836 TITLE RIB ASSY (BASKET LID) | | REV. A | |
| DRAWN | | | | SHEET 1 OF 3 | |
| CHECKED | | | | SCALE | |
| MFG. APPR. | | | | NTS | |
| APPROVED | | | | | |
| DE APPR. | | | | | |
| DATE | | 08.09.24 | | | |
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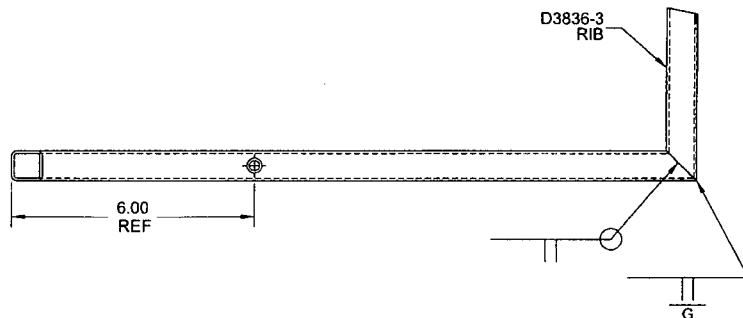
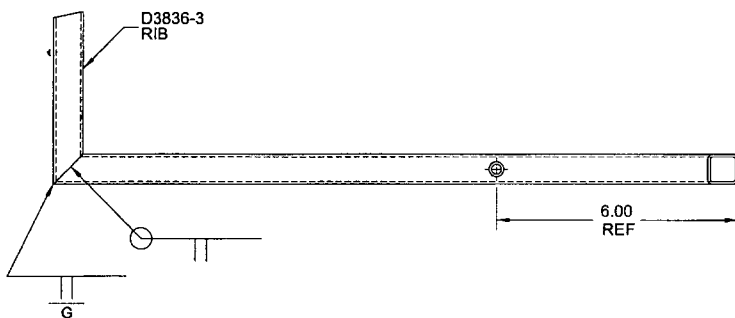
D

D



C

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B

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D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

46089

RELEASED
28/11/18 JHP

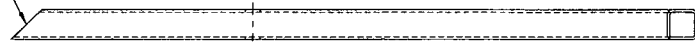
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A

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3836 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RIB ASSY (BASKET LID) | NTS |
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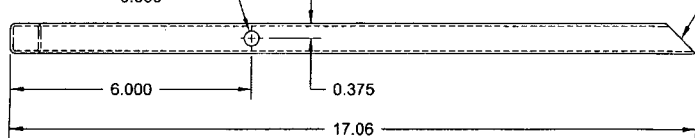
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0.75 X 45°
CHAMFER

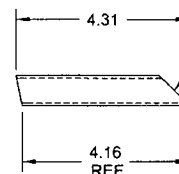


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0.75 X 45°
CHAMFER



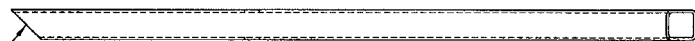
D3836-1 RIB



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CHAMFER

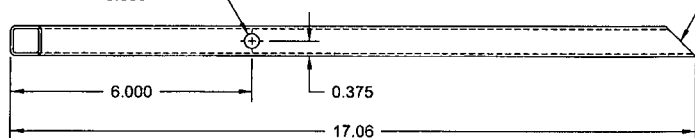
D3836-3 RIB

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CHAMFER

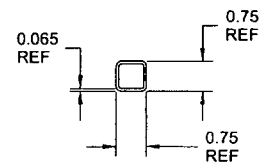


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

46089

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3836 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RIB ASSY (BASKET LID) | NTS |
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